

Work Order ID 77885

77885

Page 1

December-22-11 10:10:49 AM

Item ID: D4055-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fuel Tank Assembly

Start Date: 22/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/12/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: 114514 0.00

100

Large Fab

Memo

0.00

Large Fab

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

110

QC

Memo

0.00

Quality Control

Weld per dwg A/R Aluminum rod Batch: 114514 0.00

121

Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

QC9- Inspect visual per QSI004- Fusion Welds

0.00

122

QC

Memo

0.00

Quality Control

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Item ID: D4055-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Fuel Tank Assembly
 Start Date: 22/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Powdercoat Powder Coating M118533	Gray Sandtex (Ref: 4.3.5.6) per QSI005 4.3 GRAY PS311 AL3 AP1601-A Memo ***Mask prior to powdercoat*** Start Time: 8-30 Oven Temperature: 320°F Finish Time: 9-00	0.00 0.00							IX PM-12/01/13
180 *180* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 BL 12-1-13.
185 *185* SprayPaint Spray Painting	Seal inside of tank using Sloshing PR-1005-L Sealer as per dwg Memo 2/7 5 12/01/16	0.00 0.00							

W/O: 77885		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.01.13	170	Acceptable to use PS311 A13 AP1601-A Powder coat	M-L	12/01/13	1	CP 12.01.13 CP/092	So 12/01/13

Part No: D4055-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup	Start	*NS1*
	Stop	*NS2*

Start Date: 22/12/2011	Start Qty: 1.00	*1*
Required Date: 05/01/2012	Req'd Qty: 1.00	*1*

Cust Item ID:
Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Operation Description	Set Up/ Run Hours	Tool
Pick Kit	SP 0.00	12-01-16

*** 190 ***

Memo	0.00
Assemble as per dwg	

Small Fab

QC5- Inspect part completeness to step on W/O	0.00
---	------

200

Memo	0.00
-------------	------

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

220

Memo	✓✓✓✓	0.00
-------------	------	------

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item Name: Fuel Tank Assembly
Start Date: 22/12/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: _____	0.00							
230									
Packaging	Memo	0.00							
Packaging	PO 78174								
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

12/1/2012

MF

12-01-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 77885

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Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055
revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 *D3997-1* Placard		Manufactured	No			190	Each	4.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				4					
				73509				4					
D3997-5 *D3997-5* Placard		Manufactured	No			190	Each	13.0000	2				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				103					
				72611				95					
				73507				8					
D3997-11 *D3997-11* Placard		Manufactured	No			190	Each	11.0000	1				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				11					
				72614				2					
				73510				9					

**

Sp 12-01-16

**

Sp 12-01-16

**

Sp 12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 77885

77885

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3997-17 Manufactured No

190 Each 11.0000 1 1

D3997-17

Placard

**

SP 12-01-16

Location

Loc Qty

Loc Code

ST104

11

72617

2

73513

9

D3997-29 Manufactured No

190 Each 13.0000 1 1

D3997-29

Placard

**

SP 12-01-16

Location

Loc Qty

Loc Code

ST104

13

72622

3

73511

10

D3997-43 Manufactured No

190 Each 11.0000 1 1

D3997-43

Placard

**

SP 12-01-16

Location

Loc Qty

Loc Code

ST104

11

72629

1

73512

10

D3999-7 Manufactured No

100 Each 16.0000 1 1

D3999-7

Corner

**

SP 12-01-05

Location

Loc Qty

Loc Code

WA014

16

71695

2

75156

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 77885

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Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3999-9

Manufactured No

100

Each

7.0000

1

1

✓ ***D3999-9***

Angle

**

12.01.04

Location

Loc Qty

Loc Code

WA014

7

71696

7

D3999-11

Manufactured No

100

Each

9.0000

1

1

✓ ***D3999-11***

Earth Tab

**

12.01.06

Location

Loc Qty

Loc Code

WA

8

WA013

-8

WA014

9

71694

1

75180

8

D3999-041

Manufactured No

100

Each

6.0000

1

1

D3999-041

Baffle Assembly, Aft

**

12.01.05

Location

Loc Qty

Loc Code

WA014

6

72653

2

75230

4

D3999-043

Manufactured No

100

Each

3.0000

1

1

D3999-043

Baffle Assembly, Fwd

**

12.01.05

Location

Loc Qty

Loc Code

WA014

3

74961

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 77885

77885

Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-1
D4000-1
Fuel Supply Fitting

Manufactured No 100 Each 4.0000 1 1

**

12.01.06

Location Loc Qty Loc Code

WA014 4

74835 4

Manufactured No 100 Each 4.0000 1 1

**

12.01.05

Location Loc Qty Loc Code

WA014 4

74833 4

Manufactured No 100 Each 3.0000 3 3

**

12.01.05

Location Loc Qty Loc Code

WA014 3

73646 3

Manufactured No 100 Each 0.0000 1 1

**

12.01.05 ①

375225 ①

✓ D4000-043
D4000-043
Drain Fitting Assembly, Fwd

D4000-045

Manufactured No 100 Each 2.0000 1 1

**

12.01.05

✓ ***D4000-045***
Fuel Pickup Fitting Assembly

Location Loc Qty Loc Code

WA013 1

72078 1

WA014 1

71669 1

378266

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4000-041

Manufactured No

B 75232 100 Each 0.0000 1 1

**

12.01.05 1

D4000-041

Drain Fitting Assembly, Aft

D4001-1

Manufactured No

100 Each 4.0000 1 1

**

12.01.05

D4001-1

Fitting

Location

Loc Qty

Loc Code

WA014

4

74831

4

Manufactured No

100 Each 5.0000 1 1

**

12.01.06

D4008-11

D4008-11

Hinge Half

Location

Loc Qty

Loc Code

WA014

5

75228

5

Manufactured No

190 Each 6.0000 1 1

**

12.01.16

D4008-041

D4008-041

Fuel Filler Splash Guard Assembly

Location

Loc Qty

Loc Code

ST108

6

72792

6

Manufactured No

100 Each 8.0000 1 1

**

12.01.05

D4023-3

D4023-3

Cap and Flange

Location

Loc Qty

Loc Code

ST110

8

73514

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 77885

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Parent Item: D4055-041

D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4025-1 Manufactured No

100 Each 5.0000 1 1

D4025-1

Fuel Quantity Sender

**

SP. 12-01-16

Location

Loc Qty

Loc Code

ST141a

5

71765

4

72257

1

1/2

D4055-11 Manufactured No

100 Each 11.0000 1 1

D4055-11

Tank Front and Bottom

**

12.01.05

Location

Loc Qty

Loc Code

WA014

11

65447

2

68500

3

72249

1

74908

5

1

D4055-9 Manufactured No

100 Each 5.0000 1 1

D4055-9

Tank Back

**

12.01.05

Location

Loc Qty

Loc Code

WA014

5

75125

5

1

D4055-7 Manufactured No

100 Each 7.0000 1 1

D4055-7

Tank Fwd End

**

12.01.06

Location

Loc Qty

Loc Code

WA014

7

73476

4

74955

3

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

D4055-5

Manufactured No

100

Each

6.0000

1

1

**

D4055-5

Tank Upper Cut Out

12.01.06

Location

Loc Qty

Loc Code

ST119

1

72250

1

WA014

5

74907

5

D4055-3

Manufactured No

100

Each

7.0000

1

1

**

D4055-3

Tank Aft End

12.01.06

Location

Loc Qty

Loc Code

WA014

7

73475

3

75224

4

D4055-1

Manufactured No

100

Each

2.0000

1

1

**

D4055-1

Tank Top

12.01.05

Location

Loc Qty

Loc Code

WA014

2

71701

2

D4057-1

Manufactured No

100

Each

23.0000

3

3

**

D4057-1

Retaining Ring

12.01.05

Location

Loc Qty

Loc Code

WA013

23

71166

23

3

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Fuel Tank Assembly

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3H5A Purchased No

190 Each 22.0000 5 5

AN3H5A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST351

22

116704

1

118112

21

5x

NAS1149D0363J Purchased No

190 Each 2,253.000 5 5

NAS1149D0363.J

Washer

**

m/20142.Sp
5x.

Location

Loc Qty

Loc Code

ST298

2253

117601

61

118077

1

118612

18

118968

137

119537

2036

D4404-1 Manufactured No

190 Each 10.0000 1 1

D4404-1

Cushion

**

Sp 12-01-16.

Location

Loc Qty

Loc Code

ST242A

10

75181

7

76569

3

1x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

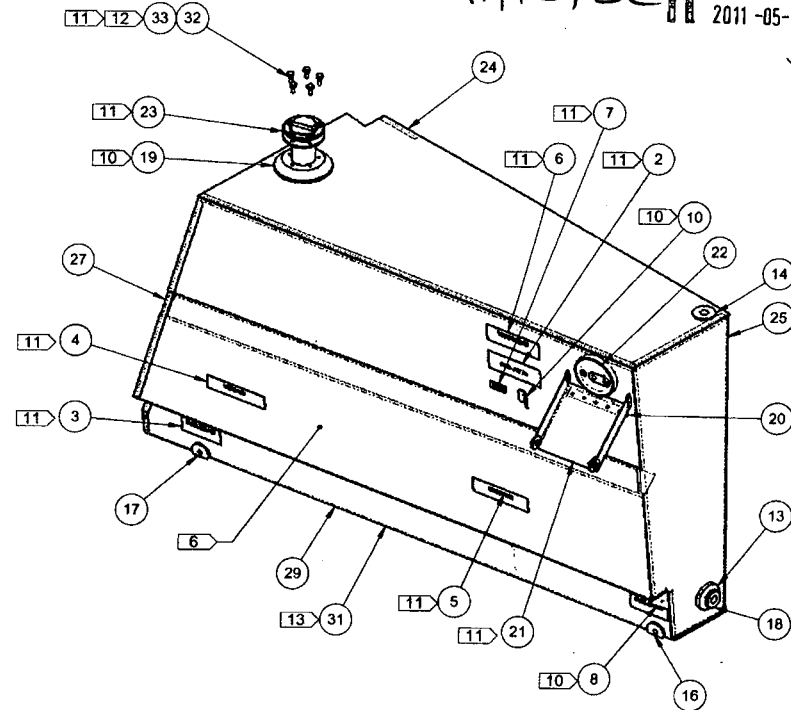
WITHOUT NOTICE
WORK ORDER

NO 77885 H.C.J

11/12/22

RELEASED
2011-05-30

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY

B	MOVE CAP POSITION AND CHANGE CAP DESIGN. CHANGE FINISH REQUIREMENTS FOR ALL PARTS. ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B SHEET 1 OF 15	
DRAWING NO. D4055		TITLE TANK	
SCALE NTS		DATE 11.05.12	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

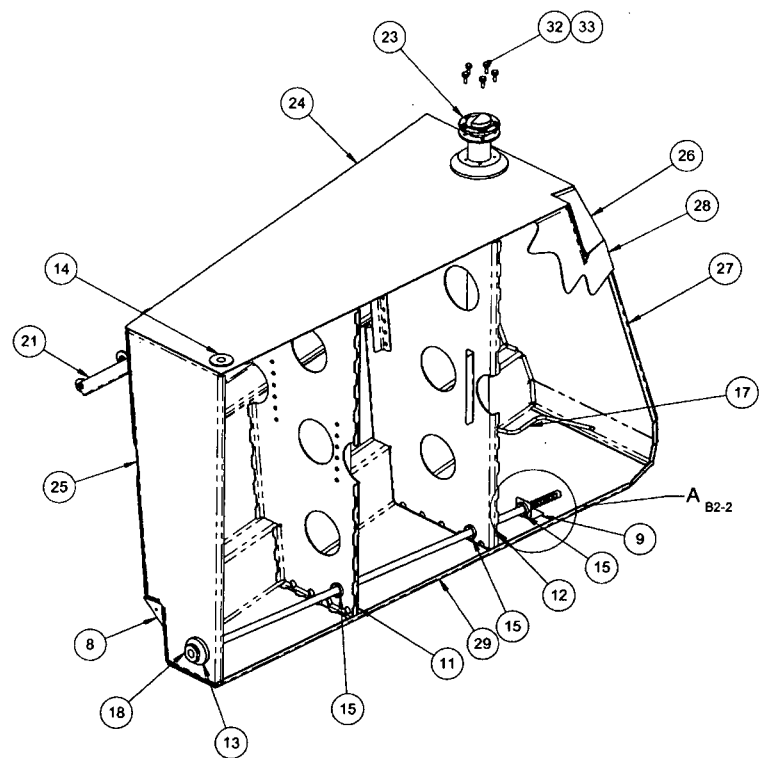
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

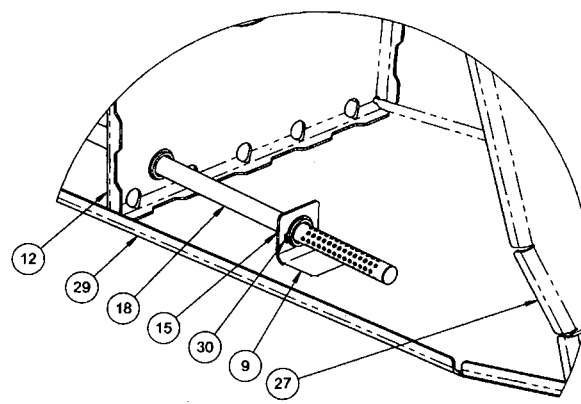
NOTE: Date & initial all entries

77885

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2011-05-30
MD



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

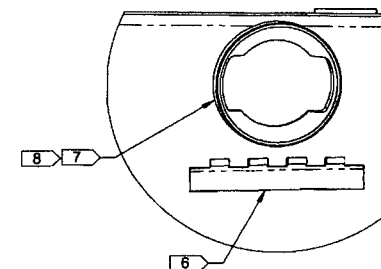
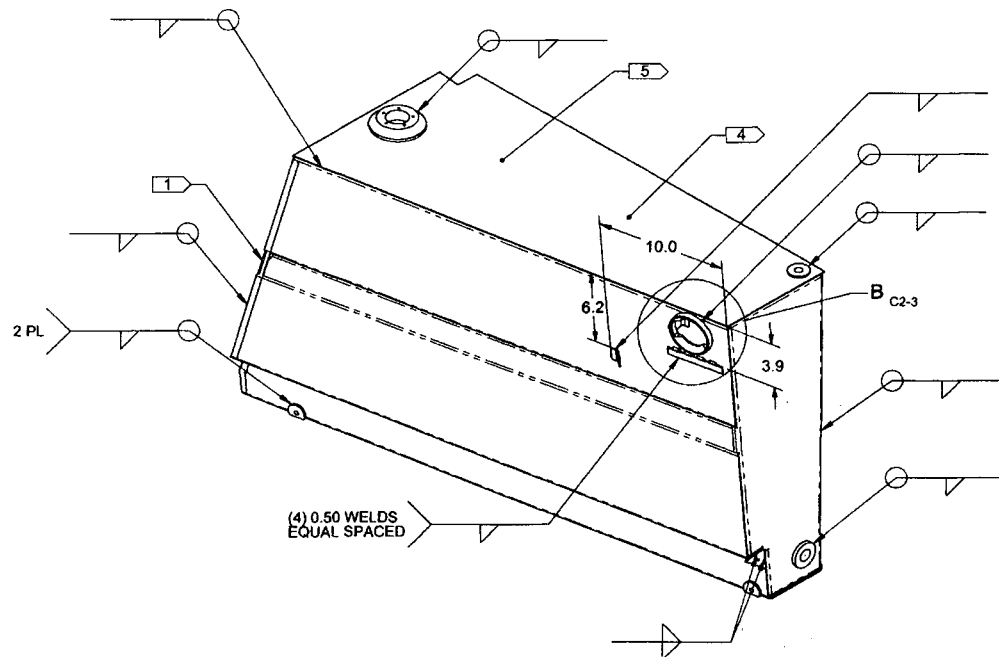
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

C4-3

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

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2011-05-30
ANT

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

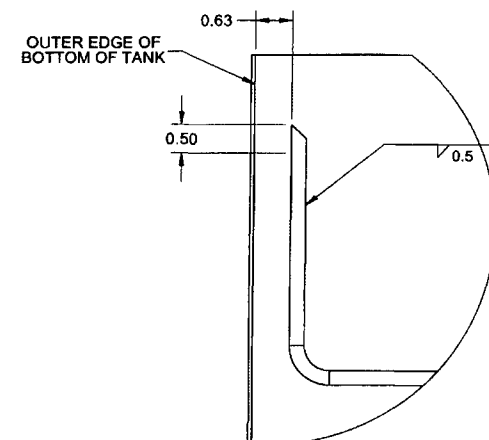
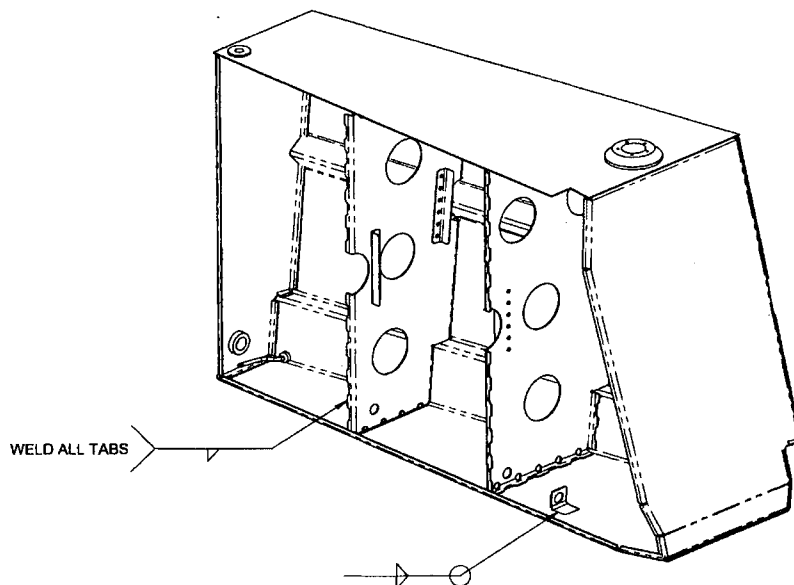
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77 885



**DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

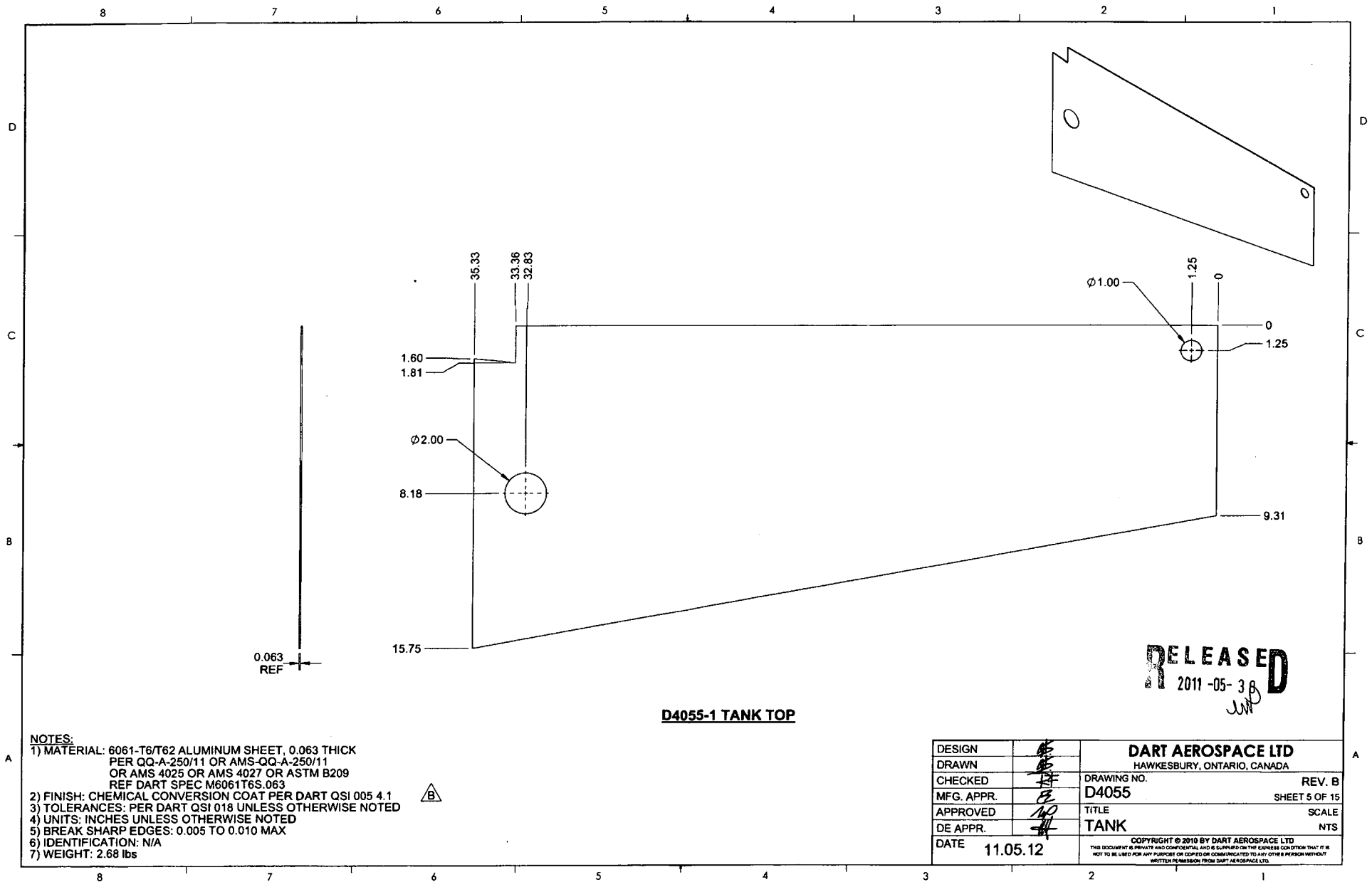
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

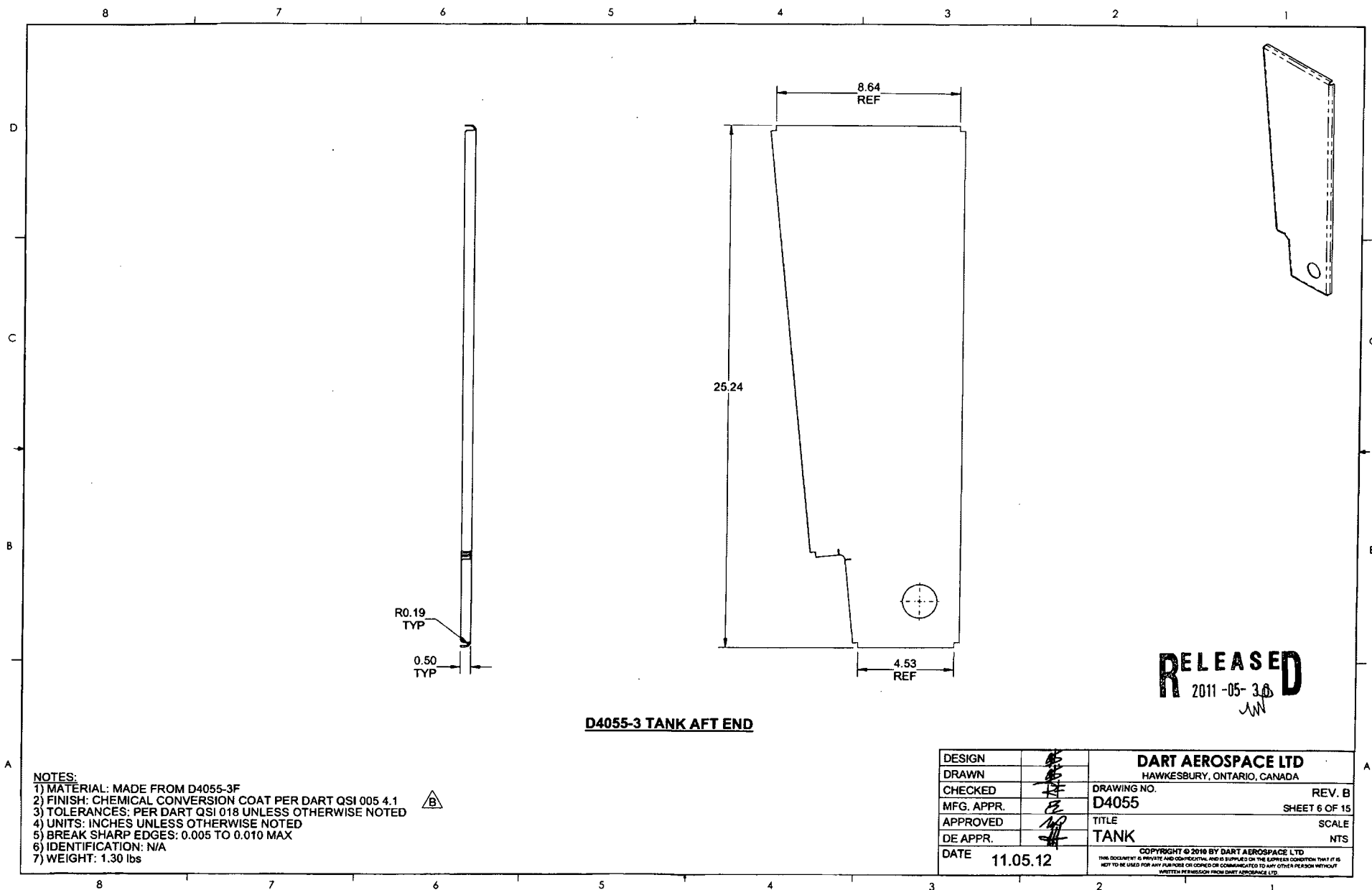
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

50885



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

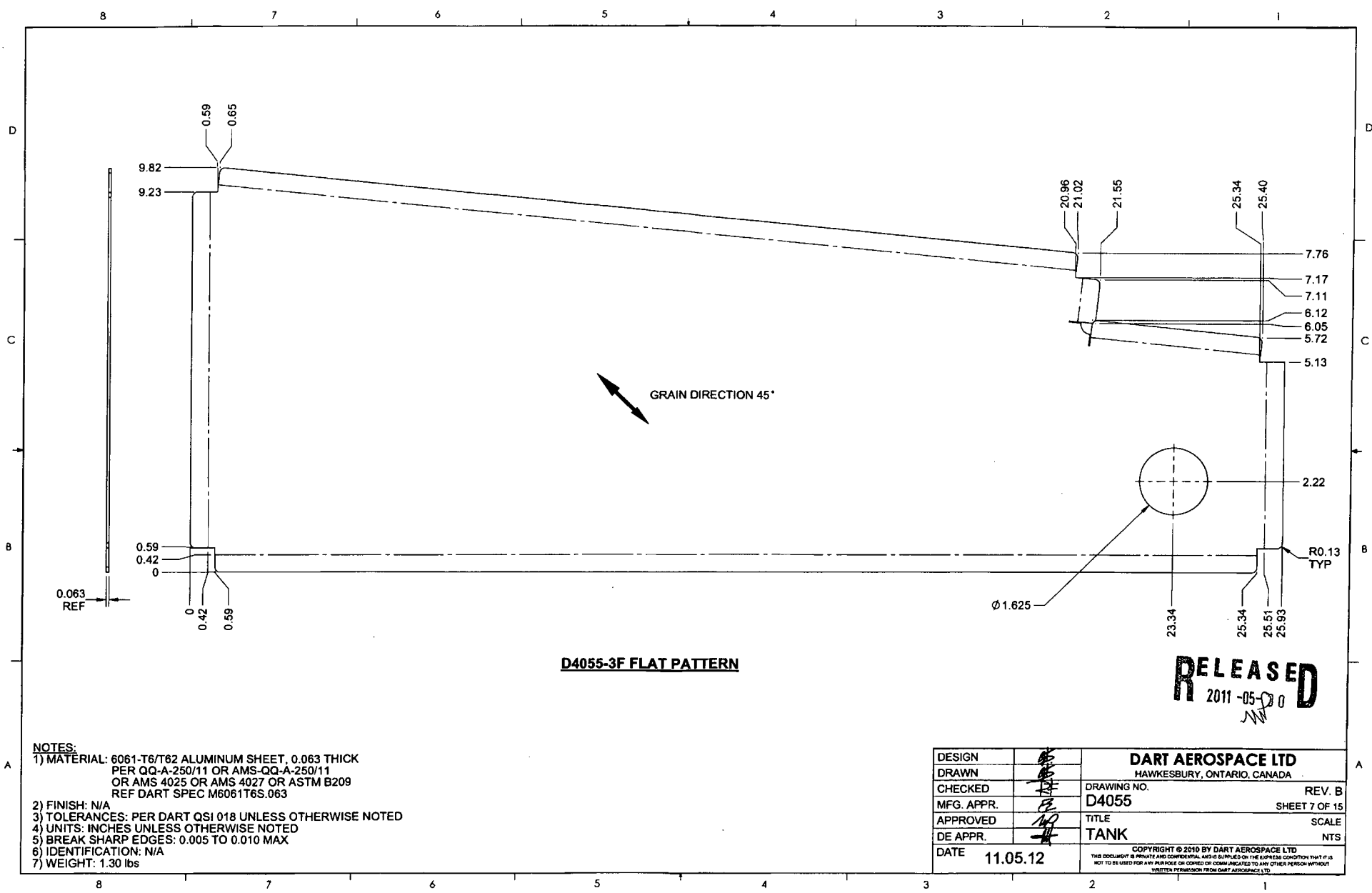
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

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2011-05-00
JW

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

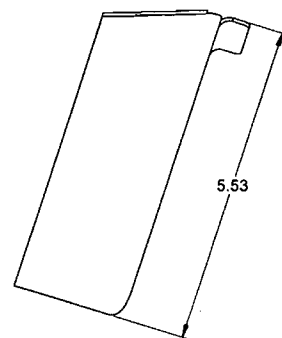
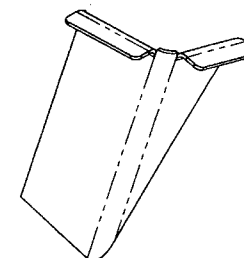
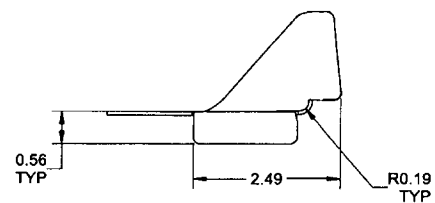
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NW

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

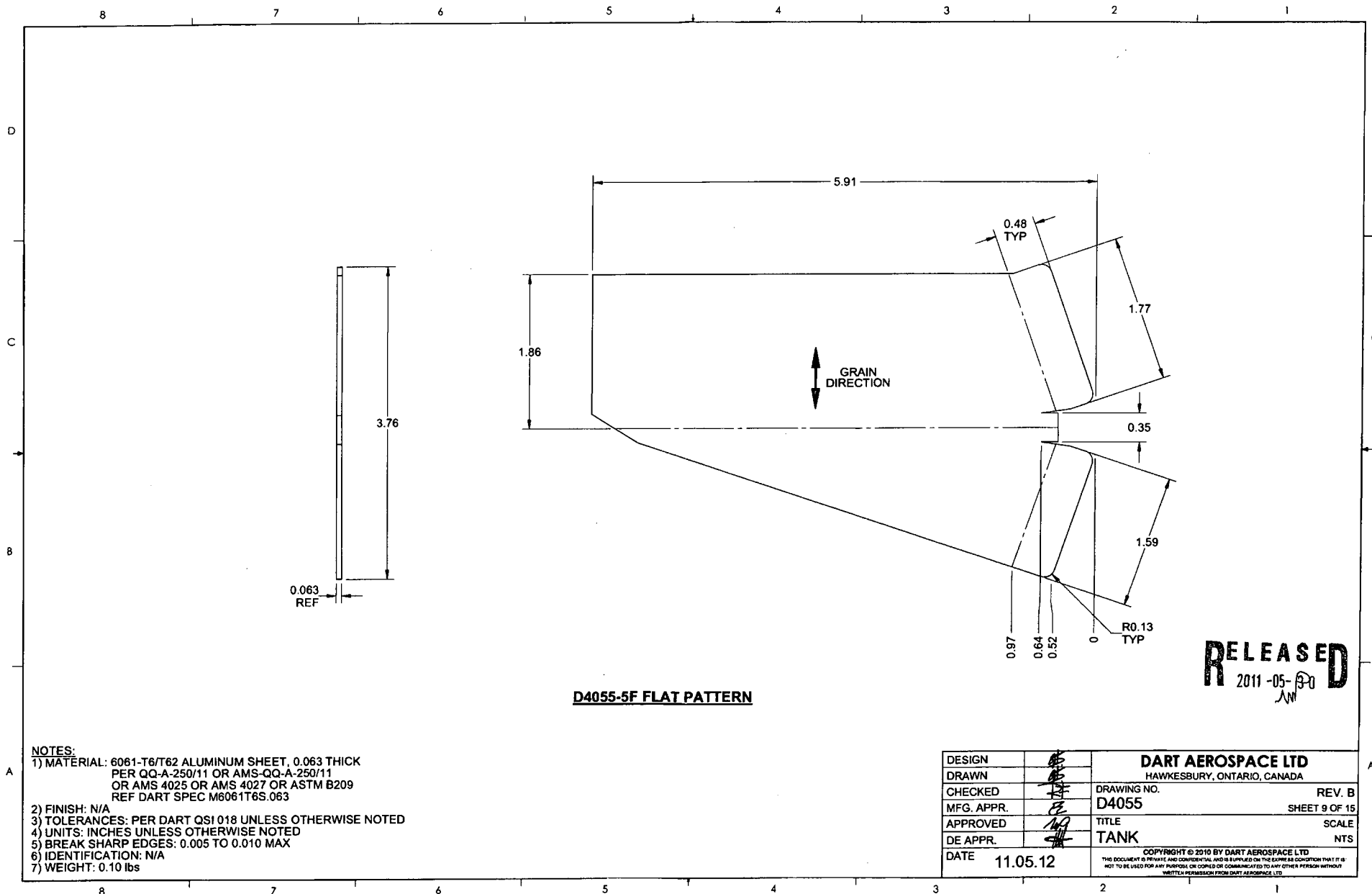
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



D4055-5F FLAT PATTERN

RELEASED
2011-05-30
AN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

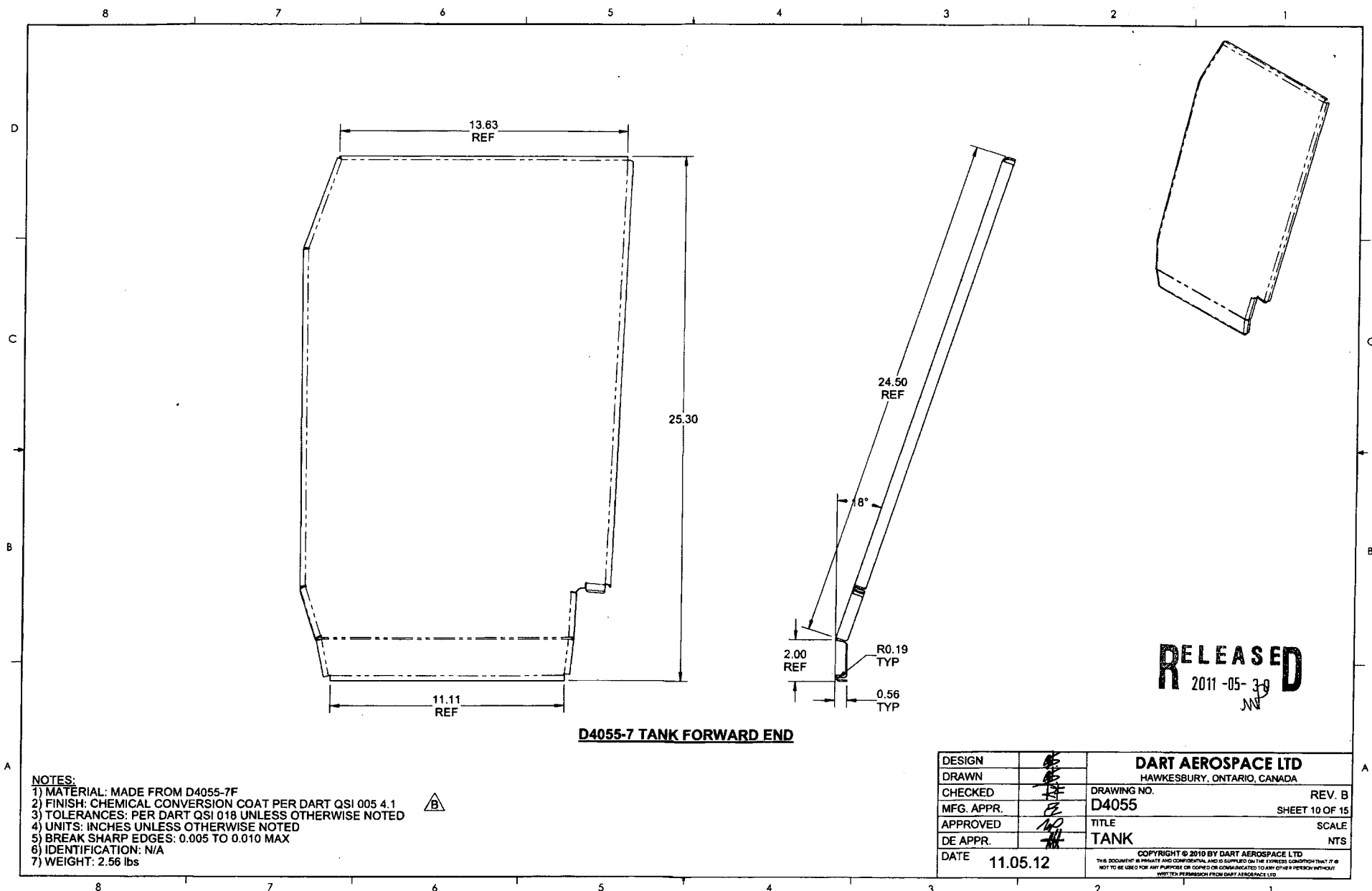
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



D4055-7 TANK FORWARD END

NOTES:

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs



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2011-05-30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

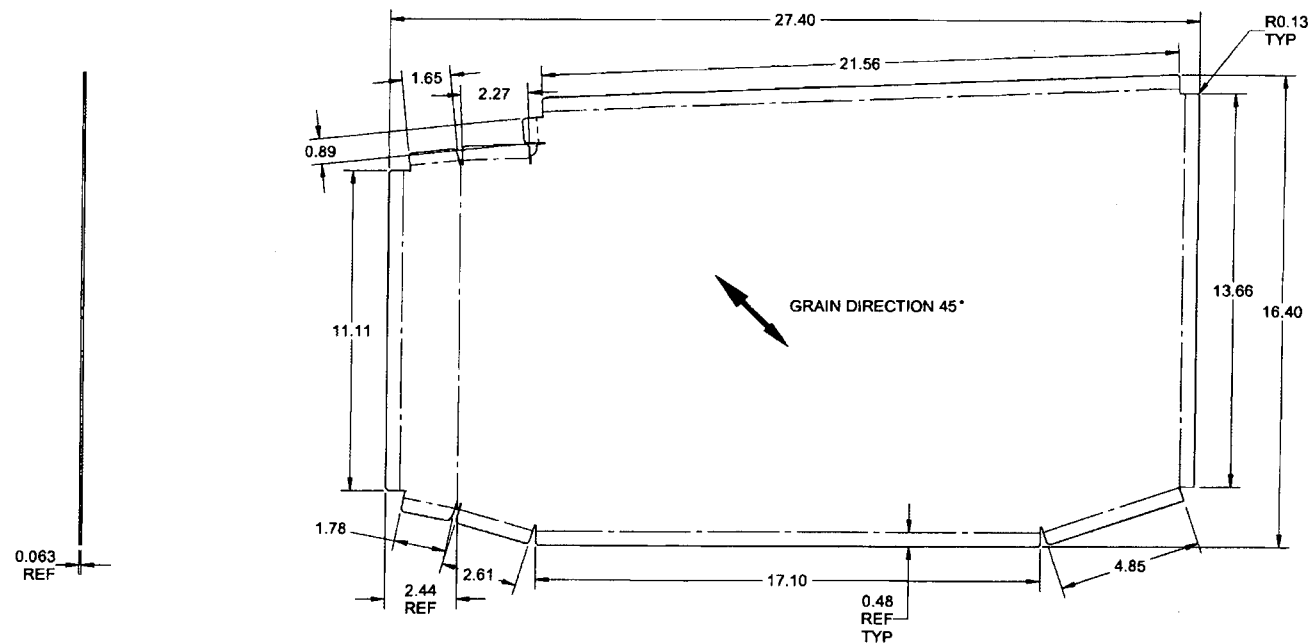
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77825



D4055-7F FLAT PATTERN

RELEASED
2011-05-13 0 D

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D4055	SHEET 11 OF 15
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

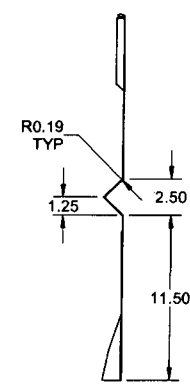
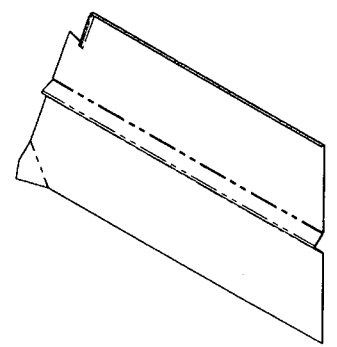
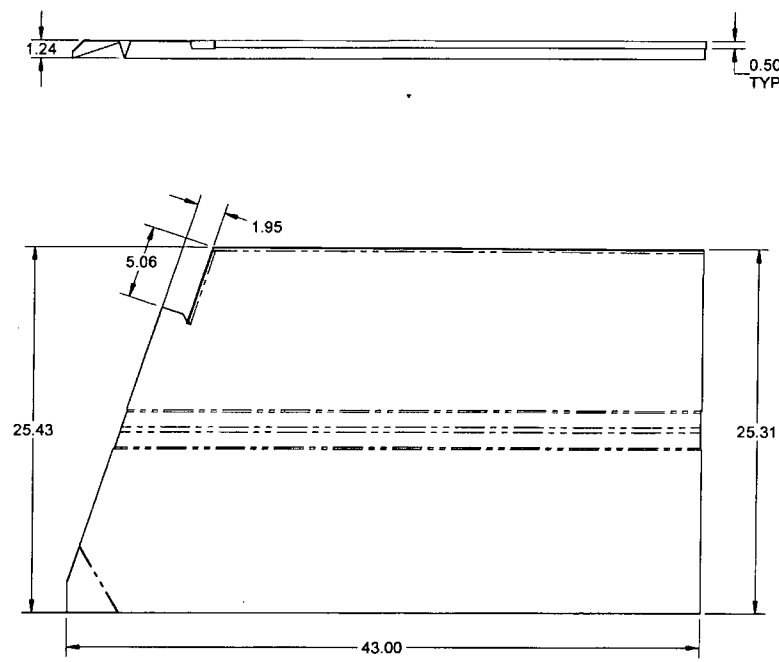
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



D4055-9 TANK BACK

RELEASED
2011-05-30
JAN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

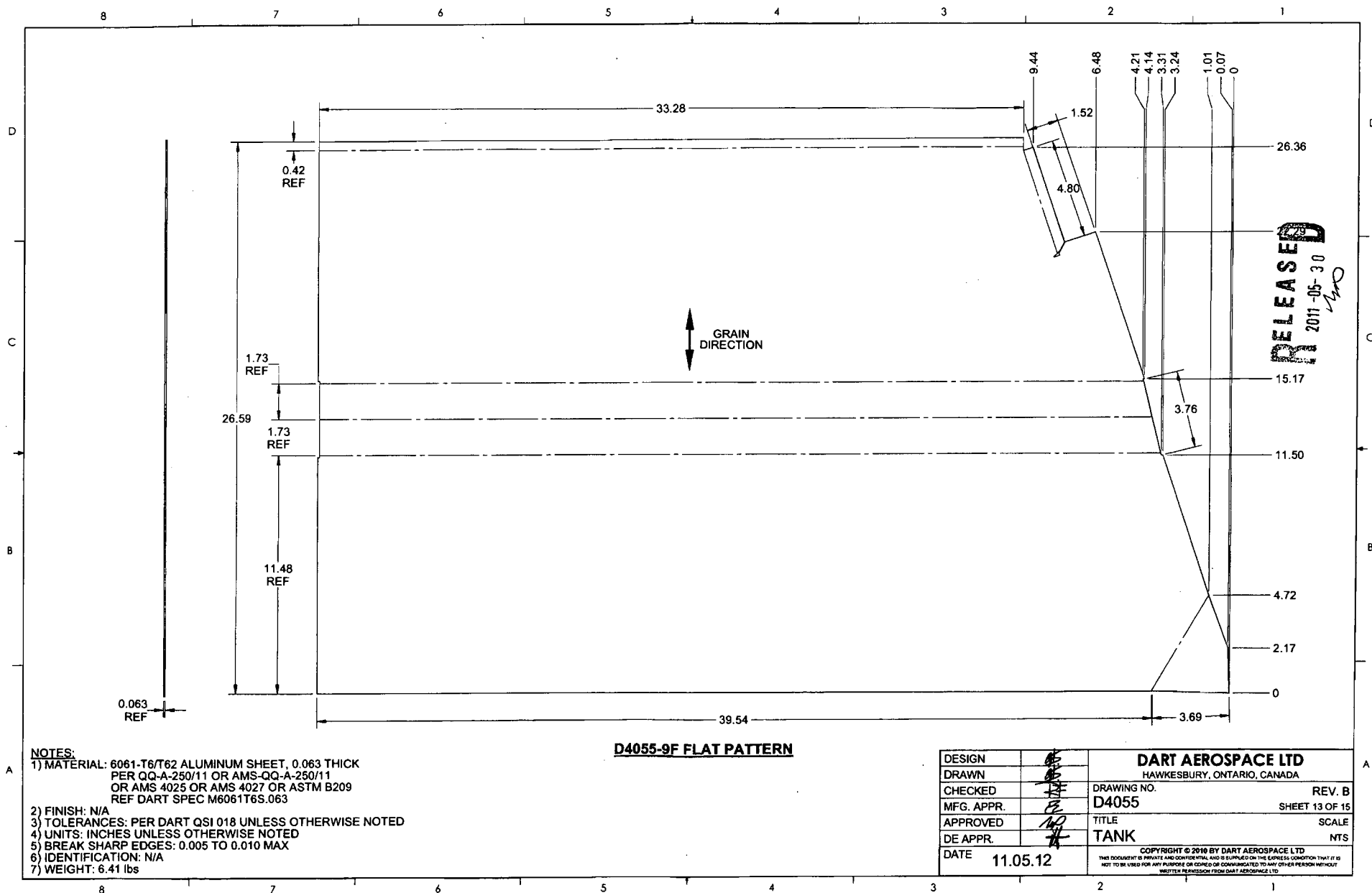
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77885



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

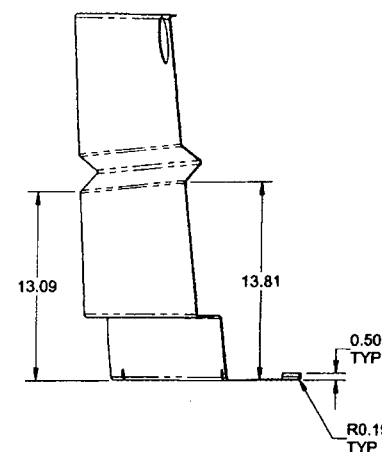
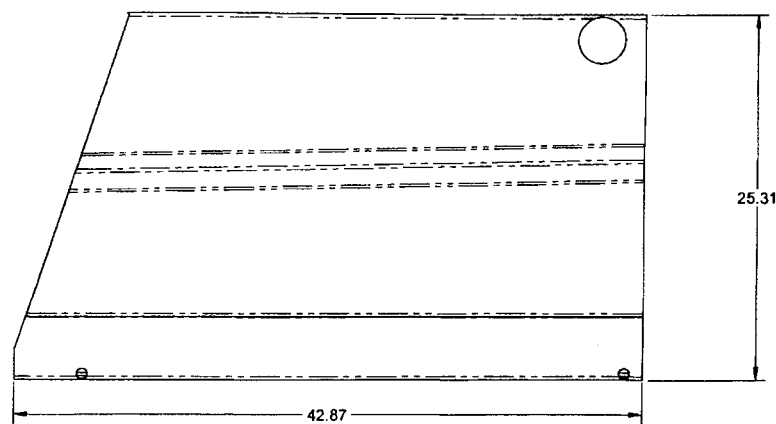
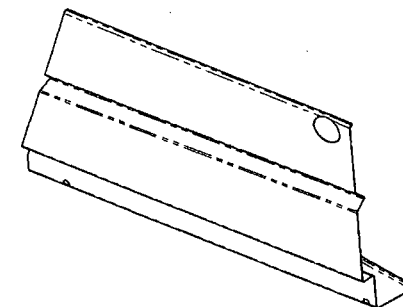
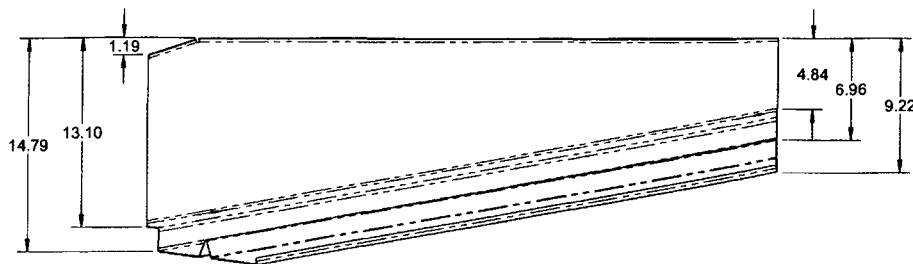
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77805









D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

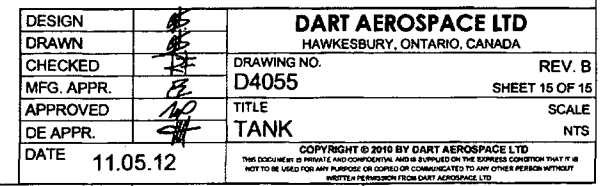
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
2011-05-30
JAH



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries